

Date: Friday, 26/01/2007 1:59:03 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW
Job Number : 30481	
Estimate Number : 10939	
P.O. Number : N/A	Part Number : D29382
This Issue : 26/01/2007 S.O. No. : N/A	Drawing Number : D2938 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 30282	Material : N/A
Written By : _____	Due Date : 12/02/2007 Qty: 6 Um: Each
Checked & Approved By : _____	
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Issue material from stock: 7075-T7351 (QQ-A-250/12)
 Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length
 (D6101-003) Batch No: B25349

SG 07.01.27 6

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet
 5-Deburr

ml / SD 07.01.27 6

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet


SF 07/02/02 6

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

ml / SD 07.01.27 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.01.26	2	TOOL RAD FOR FLANGE POCKETS SHOULD BE R0.128 INSTEAD OF R0.25 0.30				 07.01.26 PW OS 042	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/02/13

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Friday, 26/01/2007 1:59:03 PM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER
REVIEW

Job Number: 30481

Part Number: D29382

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

RG 07-02-06

6

6.0

HAND FINISHING1

HAND-FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MR/Y

07/02/07

(6X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M103141

ATTN: paint 1 pc grey

MR/Y

07/02/12

(6X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

RG 7/6/12

5W47K
1 GRAY

(6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57478

RG 7/6/12

(6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

RG 07/02/13

(6)

Job Completion



U 07-02-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30481
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.126	.128	.128	.128		
B	0.100	0.140		.128	.128	.128	.128		
C	0.100	0.140		.120	.125	.125	.122		
D	0.210	0.230		.221	.220	.220	.221		
E	1.245	1.255		1.250	1.256	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.508	2.500		
H	0.510	0.515							
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.508	2.500		
K	0.257	0.262	DT8683	.258	.258	.258	.258		
L	0.312	0.317	DT8686	.317	.317	.317	.317		
M	0.235	0.240							
N	0.100	0.140		.120	.120	.120	.120		
O	0.540	0.560		.550	.550	.545	.545		
P	0.490	0.510		.500	.500	.501	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.257	.252	.252	.252		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.320	.320	.320	.320		
X	1.250	1.270		1.260	1.255	1.260	1.261		
Y	1.565	1.585		1.574	1.573	1.574	1.575		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	07.01.27

Audited by:	RG
Date:	07.02.06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 50481
Description: 206 Saddle, Outboard, ^{Right} Left side		Part Number: A2938-2
Inspection Dwg: A2938 Rev. B		Page 1 of 1

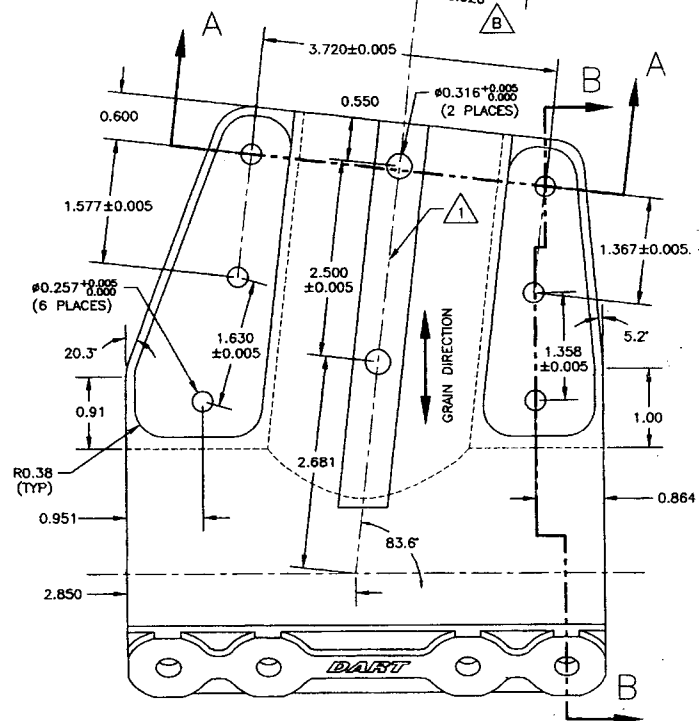
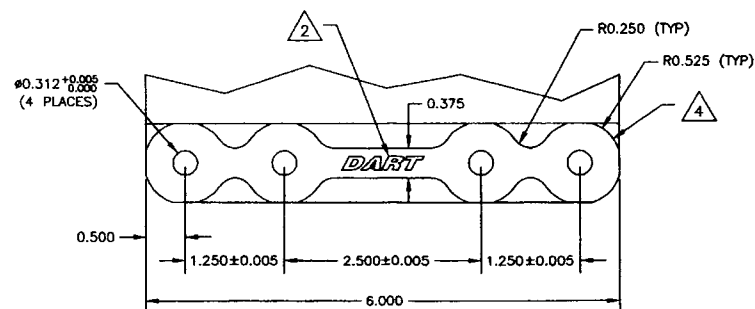
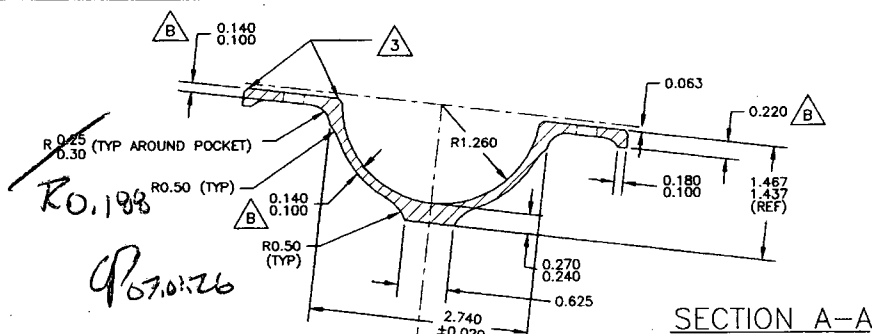
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.127	.128				
B	0.100	0.140		.128	.128				
C	0.100	0.140		.123	.126				
D	0.210	0.230		.220	.220				
E	1.245	1.255		1.250	1.256				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.503				
H	0.510	0.515							
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.508	2.508				
K	0.257	0.262	DT8683	.258	.258				
L	0.312	0.317	DT8686	.314	.314				
M	0.235	0.240							
N	0.100	0.140		.120	.120				
O	0.540	0.560		.550	.550				
P	0.490	0.510		.488	.500				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.741	2.740				
S	0.240	0.270		.252	.252				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321	DT8690	.320	.320				
X	1.250	1.270		1.255	1.255				
Y	1.565	1.585		1.573	1.573				
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

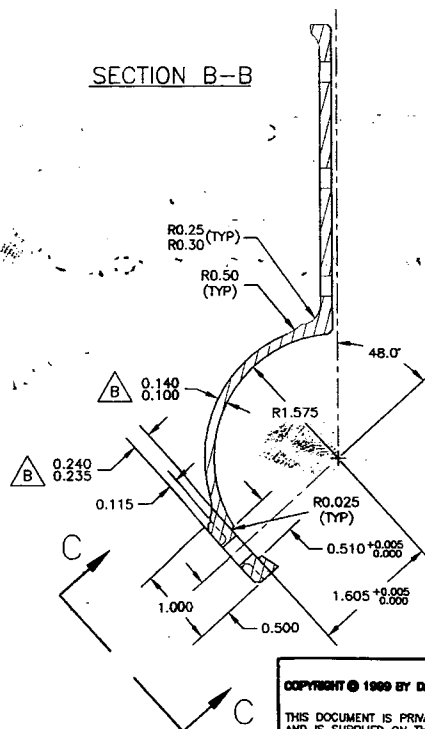
Measured by: <u>SD</u>
Date: <u>02.01.27</u>

Audited by: <u>BR</u>
Date: <u>02.02.06</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	



SECTION B-B



D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
- 3 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.050" x 45°

RELEASED
00.05.29



UNDER REVIEW

By: 1.09 CB
Change R0.38

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B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY RF	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2938 REV. B SHEET 1 OF 1
DATE	00.05.29	TITLE SADDLE OUTSIDE SCALE 2:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 19, 2006 3:31 PM
To: 'S Shahbazian'
Cc: 'Provencal, Chris'; 'Charbonneau, Eric'
Subject: RE: Radius dimension on the saddle
Importance: High

Change the drawings. I guess we will also change the 0.313 crosstube hole dimensions as well.
See D2661 to D2668 as well as D2932 to D2933.

David

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: Thursday, October 19, 2006 1:16 PM
To: Shepherd, David
Cc: Provencal, Chris; Charbonneau, Eric
Subject: Radius dimension on the saddle

Dave,
On attach saddle drawing, according to Eric the marked-up radius that reads 0.30 and 0.25, should be 0.188 since the tooling has been changed long time ago, and apparently they have been machining those radiuses to 0.188 for a while. Do you see a problem with that? if not I will go ahead and change the drawing to reflect the changes.

Serge

--
No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006

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No virus found in this outgoing message.
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Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006